

Work Order ID 70392

Monday, June 06, 2011 4:09:00 PM



ASAP For Eagle Page 1

Item ID: D4373-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Screw

Stop



Start Date: 6/6/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 10.00



Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: UMF Date: 11-06-07 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4373	PA1

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER DWG
DWG REV: PA1

DEBURR

0.00

11/06/07

11 7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

11/06/07

11 7

120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

11-06-07

11 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70392

Monday, June 06, 2011 4:09:00 PM



Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

King - table

MF 11-06-07

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 06, 2011 4:08:55 PM

Page 1

Work Order ID: 70392



Parent Item: D4373-1



Parent Item Name: Screw

Start Date: 6/6/2011

Required Date: 6/7/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 11-03-31 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M174R0.750

Purchased

No

100

f

19.4750

0.166

1.747368



17-4 round bar .750

1/6/7

Location

Loc Qty

Loc Code

MAT030

19.475

117683

19.475

1.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 70392
Description: Floor Hardware		Part Number: N4343-1
Inspection Dwg: N4343 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

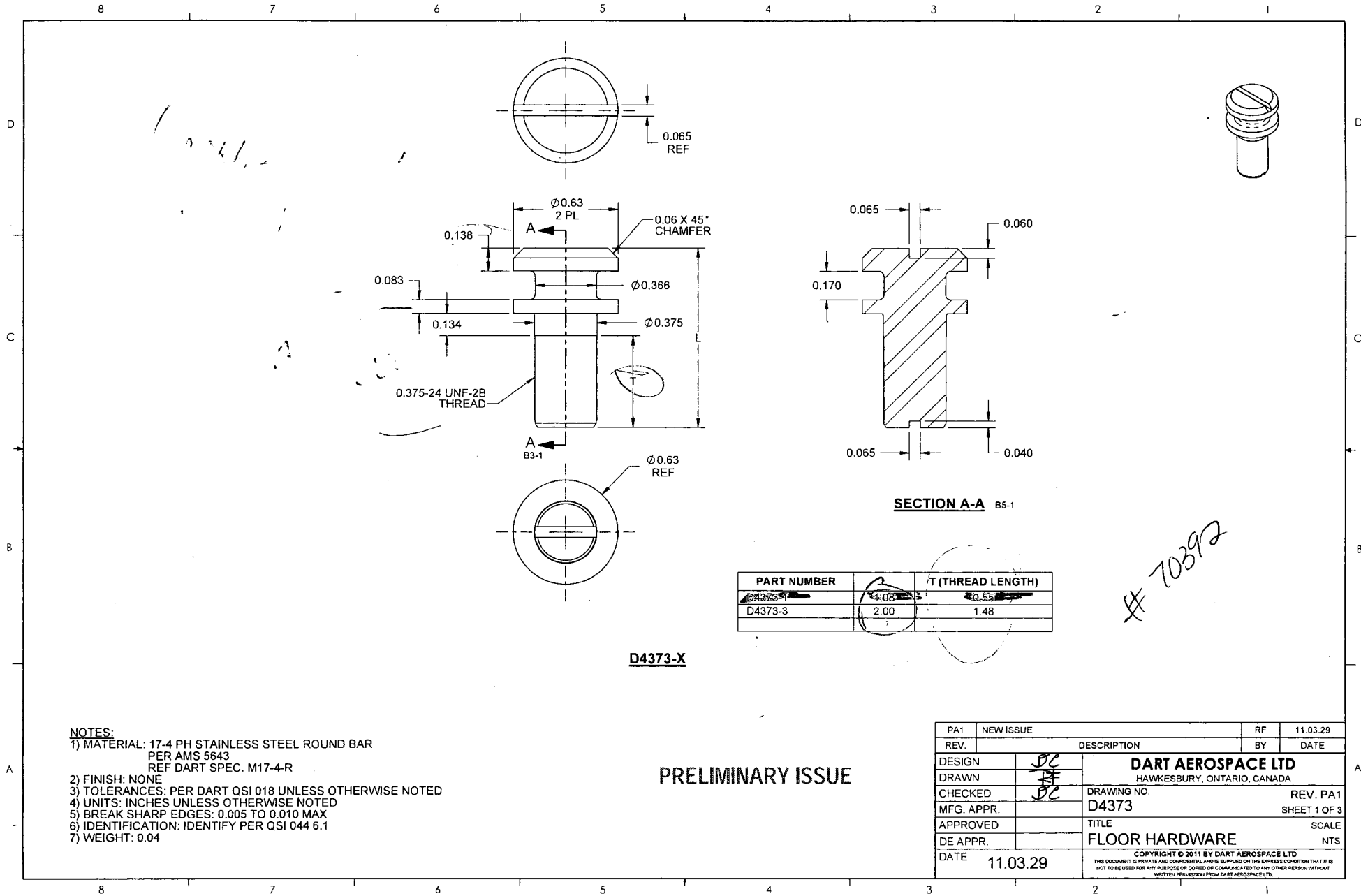
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.06510	±.010	.064	—		RA26	Milling op
Ø.63	±.030	Ø.630	/			
.138	±.010	.140	/			
.170	—	.172	/			
.083	—	.083	/			
.134	—	.140	/			
Ø.55	±.030	.0585	/			
1.08	±.030	1.079	/			
Ø.375	±.010	.368	/			
Ø.366	—	.367	/			
.040	—	.042	/		RA26	Milling op
.060	—	.062	—		RA26	
3/8-24UNF-2B	N/A		/			
Major Ø	.3667/.3739	.368	/			
M.O.W.	.3939/.3977	.395	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 11/6/07	Date: 11-06-07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

92



D4373-X

SECTION A-A 85-1

PART NUMBER	T (THREAD LENGTH)
D4373-1	4.08
D4373-3	2.00
	4.55
	1.48

70392

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL ROUND BAR
PER AMS 5843
REF DART SPEC. M17-4-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04

PRELIMINARY ISSUE

PA1	NEW ISSUE	RF	11.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	BF		
CHECKED	DC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.03.29		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4373
REV. PA1
SHEET 1 OF 3
TITLE FLOOR HARDWARE
SCALE NTS

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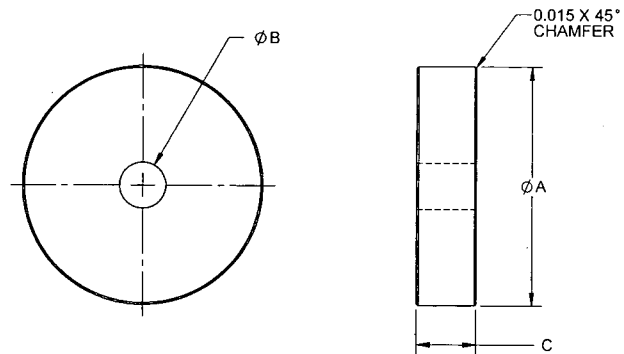
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4373-Y

PART NUMBER	ØA	ØB	C
D4373-5	1.625	0.386	0.500
D4373-7	2.000	0.386	0.500

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

PRELIMINARY ISSUE

DESIGN	<i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>		
CHECKED	<i>DC</i>	DRAWING NO. D4373	REV. PA1
MFG. APPR.		TITLE FLOOR HARDWARE	SHEET 2 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE LTD	
DATE	11.03.29	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

70392

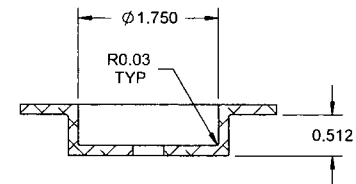
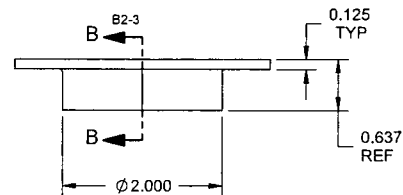
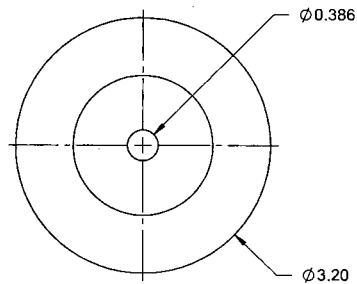
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

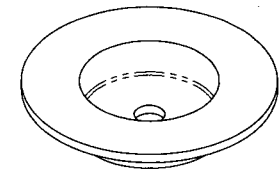
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION B-B C5-3



D4373-9 CUP

70392

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs

PRELIMINARY ISSUE

DESIGN	<i>DC</i>	DART AEROSPACE LTD	
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DC</i>	DRAWING NO. D4373	REV. PA1
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		FLOOR HARDWARE	NTS
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